

What is claimed is:

1. A multi-layered pouch capable of holding such as pharmaceutical related items, comprising:

first and second sides engaged along a plurality of extending edges thereof to define a hermetically sealed interior for holding the items, each of said sides further comprising:

an outermost high density polymer film coated with a clay material; a lower density polymer film secured to an inwardly facing side of said high density polymer film;

a metal foil layer secured to an exposed inwardly facing side of said lower density film; and

a sealant resin layer secured to an exposed inwardly facing side of said foil layer;

said pouch exhibiting tear resistant properties.

2. The pharmaceutical pouch as described in claim 1, said higher density polymer film further comprising a clay coated polyethylene film.

3. The pharmaceutical pouch as described in claim 2, said clay coated higher density polymer film further comprising a gauge thickness established in a range of 200 to 300.

4. The pharmaceutical pouch as described in claim 1, said lower density polymer film further comprising a low density polyethylene laminating resin.
5. The pharmaceutical pouch as described in claim 1, said lower density polymer film further comprising a polyethylene/acid copolymer extrusion laminating resin.
6. The pharmaceutical pouch as described in claim 1, said foil layer further comprising a 35 gauge aluminum foil.
7. The pharmaceutical pouch as described in claim 1, said sealant resin further comprising a polyethylene/acid copolymer resin.
8. The pharmaceutical pouch as described in claim 1, said sealant resin further comprising an Ionomer extrusion resin.
9. The pharmaceutical pouch as described in claim 1, said first and second sides each exhibiting a substantially rectangular shape having first, second, third and fourth sides.
10. The pharmaceutical pouch as described in claim 9, further comprising heat sealing a bottom edge and first and second side extending edges of said pouch.

11. The pharmaceutical pouch as described in claim 10, further comprising an open top edge of said pouch being sealed following filling with the pharmaceutical related items.

12. A multi-layered pouch capable of holding at least one item, comprising: first and second sheets of material engaged along a plurality of extending edges thereof to define a hermetically sealed interior for holding the items, each of said sheets further comprising:

- a first polymer film coated with a clay material;
- a second polymer film secured to a facing side of said first polymer film;
- a foil secured to an exposed facing side of said second film; and
- a sealant secured to an exposed facing side of said foil;

said pouch exhibiting tear resistant properties.

13. The pouch as described in claim 12, said first polymer film further comprising a clay coated high density polyethylene film.

14. The pouch as described in claim 12, said second polymer film further comprising at least one of a polyethylene laminating resin and a polyethylene/acid copolymer extrusion laminating resin.

15. The pouch as described in claim 14, said second polymer film exhibiting a density lower than said first polymer film.

16. The pouch as described in claim 12, said foil further comprising an aluminum foil.

17. The pouch as described in claim 12, said sealant further comprising at least one of a polyethylene/acid copolymer sealant resin and an Ionomer extrusion sealant resin.

18. A multi-layered pouch capable of holding such as pharmaceutical related items, comprising:

first and second sides, each exhibiting a rectangular shape having first, second, third and fourth sides and which are heat sealingly engaged along extending and interconnected edges thereof to define a hermetically sealed interior for holding the items, each of said sides further comprising:

a first outer polyethylene film exhibiting a first density and which is coated with a clay material;

a second polymer film including at least one of a polyethylene laminating resin and a polyethylene/acid copolymer extrusion laminating resin, said second film being secured to an inner facing side of said high density polymer film and exhibiting a second density less than that of said first polymer film;

an aluminum foil layer secured to an exposed inner facing side of said second polymer film; and  
a sealant resin layer secured to an exposed inner facing side of said foil layer;  
said pouch exhibiting tear resistant properties.